

Date: Tuesday, 5/23/2006 7:14:18 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D205-541-044
Job Number	: 27213		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z_CUSTOM
This Issue	: 5/23/2006 S.O. No. : N/A	Drawing Number	: UPDATE PAPERWORK
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : N/A	Drawing Revision	: N/A
Previous Run	: 00015	Material	: N/A
Written By	: <u>SEE ABOVE USER & DAR</u>	Due Date	: 5/30/2006
Checked & Approved By	: " " " " " "	Qty:	1 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

ADD NEW PAPERWORK TO KITS IN STOCK

SH96-120 ISSUE 3

ICA-D205-541 REV.1

D205-541 REV.F

FMS-D205-541 REV.E; FMS-D214-541 REV.A; FMS-D412-541 REV.A

TO KITS IN STOCK

D205-541-044

319530

CO 6/10/23 (1)

2.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

INSPECT LEVEL 21

SP 6/10/25 (1)

Job Completion



CA 6/10/25

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD		ECN #: 811	
Date: 06.05.19		Created By: <i>[Signature]</i>	
Project No: D205-541		Checked By:	
Project Name: HELI UNITY BASKET		Approved By: <i>[Signature]</i>	
		(Management if reqd)	
Description of Change:			
RELEASE SH 96-120 ISSUE 3 ICA-D205-541 REV. 1 D205-541 REV. F FMS-D205-541 REV. E FMS-D214-541 REV. A & FMS-D412-541 REV. A			
Engineering Actions	Yes	No	Responsible
Required Documents Under Review?	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Update Blue/Pink Folder/Electronic File	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	KJ
Update DSI Folder/Electronic File	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Update D-Part Master Binder	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Update Grey Project Binder	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	KJ
Update DEO/DSI Binder	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Update Master Document List (MDL)	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	RE/KJ
Update Drawing Approval Record (DR)	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	RE/KJ
Update Change Record Form	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Move Electronic File	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Notify TCA of Change	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	DS
Notify FAA of Change	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Update QSI 021 (TC/FAA STC)	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	KJ
Update QSI 036 (K-Kits)	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Scan Documents	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	KJ
Update Accpac Database	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Update Access Database	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	KJ
Verification ARC	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	KJ
Create/Update STC Approval List	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	KJ
Update Prod. Dev. Summary	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Create/Update COSS (Estimate/BOM)	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Create/Update PPP's	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	KJ
Update Paperwork Kits in Production	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	KJ
Update Paperwork Kits in Stock	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	LL
Rework/Scrap Current Production	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Rework/Scrap Kits in Stock?	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Update Qpulse	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Create/Update Controlled PDF Dwgs	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Create/Update FAI sheets	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Create/Update CNC Programs	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Create/Update Tooling	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Create/Update DXF File	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
MPP required?	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Notify Previous Customers	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Notify Eurocopter France	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
Notes:			
<div style="border: 1px solid black; padding: 5px; display: inline-block;"> 1-541-044 IN STOCK </div>			

ECN Complete: _____ Date: _____

36

DART AEROSPACE LTD		Work Order:	19530
Description: HELI-UTILITY-BASKET, RH		Part Number:	D205-541-044
Drawing: D205-541 Rev. E DSI 9131		Qty:	1
Page 1 of 2			

Step	Location	Procedure	By	Date	Qty																																																																																																																																																																
1	DC	Issue Travellers for: D205-541-044 Utility-Basket, RH D3053-042 Base D2512 Lid Drawing not required																																																																																																																																																																			
		Batch 19530 19530 19530																																																																																																																																																																			
2	DC	Photocopy bluefile and type labels per PPP D205-541-044 CHG002																																																																																																																																																																			
3	WS	Go to traveler D3053-042 & D2512																																																																																																																																																																			
4	KP	Pick: Assembly Kit <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D2022-101</td><td>Spacer</td><td>B19265</td></tr><tr><td>1</td><td>D2258-300</td><td>Label</td><td>B16384</td></tr><tr><td>1</td><td>D2332-041</td><td>Prop Ass'y</td><td>B19413</td></tr><tr><td>1</td><td>D2530</td><td>Handle Ass'y</td><td>B19487</td></tr><tr><td>2</td><td>D2535</td><td>Spring</td><td>B17762</td></tr><tr><td>2</td><td>D2537</td><td>Bushing</td><td>B18840</td></tr><tr><td>2</td><td>D2931</td><td>Bumper</td><td>B18293</td></tr><tr><td>2</td><td>AN3-16A</td><td>Bolt</td><td>M10454</td></tr><tr><td>2</td><td>AN4-7A</td><td>Bolt</td><td>M13237</td></tr><tr><td>1</td><td>AN4-22A</td><td>Bolt</td><td>M12490</td></tr><tr><td>1</td><td>AN4-24A</td><td>Bolt</td><td>M11492</td></tr><tr><td>4</td><td>AN5-17A</td><td>Bolt</td><td>M13237</td></tr><tr><td>2</td><td>AN960JD416</td><td>Washer</td><td>M13356</td></tr><tr><td>2</td><td>AN960JD416L</td><td>Washer</td><td>M13154</td></tr><tr><td>4</td><td>AN960JD516</td><td>Washer</td><td>M11989</td></tr><tr><td>2</td><td>AN960JD8</td><td>Washer</td><td>M19636</td></tr><tr><td>4</td><td>AN970-4</td><td>Washer</td><td>M12983</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M13536</td></tr><tr><td>4</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M12620</td></tr><tr><td>4</td><td>MS21042L5</td><td>Nut (or -5)</td><td>M15289</td></tr><tr><td>2</td><td>MS20600AD4W3</td><td>Rivet</td><td>M12289</td></tr></table> Pick: Packing Kit <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2199-1</td><td>Strut</td><td>B18021</td></tr><tr><td>1</td><td>D2199-23</td><td>Strut</td><td>B11406-B10730-B12793</td></tr><tr><td>1</td><td>D2199-25</td><td>Strut</td><td>B10731-B10794-B11407</td></tr><tr><td>1</td><td>D2498</td><td>Mounting lug</td><td>B3924</td></tr><tr><td>1</td><td>D2499</td><td>Mounting lug</td><td>B17619</td></tr><tr><td>2</td><td>D2515</td><td>Bushing</td><td>B10742</td></tr><tr><td>1</td><td>D3052-1</td><td>Mounting lug</td><td>B18143</td></tr><tr><td>2</td><td>AN4-7A</td><td>Bolt</td><td>M13237</td></tr><tr><td>3</td><td>AN4-12A</td><td>Bolt</td><td>M13437</td></tr><tr><td>9</td><td>AN4-13A</td><td>Bolt</td><td>M13536</td></tr><tr><td>2</td><td>AN4-14A</td><td>Bolt</td><td>M13103</td></tr><tr><td>1</td><td>AN5-7A</td><td>Bolt</td><td>M15760</td></tr><tr><td>1</td><td>AN5-13A</td><td>Bolt</td><td>M11931</td></tr><tr><td>29</td><td>AN960JD416</td><td>Washer</td><td>M13356</td></tr><tr><td>3</td><td>AN960JD516</td><td>Washer</td><td>M11989</td></tr><tr><td>16</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M12620</td></tr><tr><td>2</td><td>MS21042L5</td><td>Nut (or -5)</td><td>M15289</td></tr></table>	Qty	Part Number	Description	Batch	2	D2022-101	Spacer	B19265	1	D2258-300	Label	B16384	1	D2332-041	Prop Ass'y	B19413	1	D2530	Handle Ass'y	B19487	2	D2535	Spring	B17762	2	D2537	Bushing	B18840	2	D2931	Bumper	B18293	2	AN3-16A	Bolt	M10454	2	AN4-7A	Bolt	M13237	1	AN4-22A	Bolt	M12490	1	AN4-24A	Bolt	M11492	4	AN5-17A	Bolt	M13237	2	AN960JD416	Washer	M13356	2	AN960JD416L	Washer	M13154	4	AN960JD516	Washer	M11989	2	AN960JD8	Washer	M19636	4	AN970-4	Washer	M12983	2	MS21042L3	Nut (or -3)	M13536	4	MS21042L4	Nut (or -4)	M12620	4	MS21042L5	Nut (or -5)	M15289	2	MS20600AD4W3	Rivet	M12289	Qty	Part Number	Description	Batch	1	D2199-1	Strut	B18021	1	D2199-23	Strut	B11406-B10730-B12793	1	D2199-25	Strut	B10731-B10794-B11407	1	D2498	Mounting lug	B3924	1	D2499	Mounting lug	B17619	2	D2515	Bushing	B10742	1	D3052-1	Mounting lug	B18143	2	AN4-7A	Bolt	M13237	3	AN4-12A	Bolt	M13437	9	AN4-13A	Bolt	M13536	2	AN4-14A	Bolt	M13103	1	AN5-7A	Bolt	M15760	1	AN5-13A	Bolt	M11931	29	AN960JD416	Washer	M13356	3	AN960JD516	Washer	M11989	16	MS21042L4	Nut (or -4)	M12620	2	MS21042L5	Nut (or -5)	M15289			
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inspection of Kit ———

LB 03-10-01 mm

RELEASED
02/09/03 RF

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncb.doc

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	19530
Description: Heli-utility-basket, RH	Part Number:	D205-541-044
Drawing: D205-541 Rev. E	Qty:	1
Page 2 of 2		

Step	Location	Procedure	By	Date	Qty												
5	GA	Assemble as per Dwg D205-541 Attach Travellers: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3053-042</td><td>Base</td><td>B19530</td></tr><tr><td>1</td><td>D2512</td><td>Lid</td><td>B19530</td></tr></table>	Qty	Part Number	Description	Batch	1	D3053-042	Base	B19530	1	D2512	Lid	B19530	SB	03/09/17	1
Qty	Part Number	Description	Batch														
1	D3053-042	Base	B19530														
1	D2512	Lid	B19530														
6	QC5	Inspect for foreign object per QSI 024 & Assembly work to Step 5	RB	03.09.24	1												
7	PK	Box and identify as per PPP D205-541-044	REV. B Q	03-09-30	1												
8	AC	Cost / part: 1526.09	JNM	03-10-01	1												
9	DC	Close Work Order and Ensure Travellers Attached Inspect Level 21 1498.50 Travellers: D205-541-044 D3053-042 D2512	HA	23.10.02	1												

Rev	Date	Change	Revised By	Approved
A	02.01.08	New issue	NG	
B	02.07.24	Re-format Location; Modify Step1, 5, 8 & 9	KJ	
C	02.08.30	Re-format Step 4 procedure column; CHG002	KJ RF	QJ

RELEASED

02/09/03 RF

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 27, 2003
10:49 am

Work Order No	: 0019530	Department Code:	
Project Name	: *D205-541-044	Burden Flags	: NNNNNNNN
Project For	: WK336	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: *D205-541-044	Invoice Number	:
Description	: Heli-Utility-Basket, RH	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 1	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-27-03		
Est Finish Date	: 09-18-03	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====	=====	=====	=====	=====	=====
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Testing Hours	: 0.00	0.00	0.00		
Testing Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
SubContract Hours	: 0.00	0.00	0.00		
SubContract	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====	=====	=====	=====		
Burden	: 0.00	0.00	0.00		
=====	=====	=====	=====		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

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DART AEROSPACE LTD	Work Order:	19530
Description: 212 Basket Base Ass'y RH	Part Number:	D3053-042
Drawing: D3053 Rev. A ; D2235 Rev. B1	Qty:	1

Step	Location	Procedure	By	Date	Qty																				
1	DC	Open Traveller Dwg not required	AJ	03.08.27	1																				
2	WS	Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: <u>1/3574</u> Cut Qty. 5 D2235-3 from: Qty. 5 D3166-1 ~ Batch: <u>6/2078</u> <u>6/9513</u>	MS	03/08/28	1																				
3	WS	Drill holes in D3053-3 as per Dwg D3053	MS	03/08/28	1																				
4	WS	Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D2327-3 -</td><td>Bushing</td><td><u>1/8597</u></td></tr><tr><td>2</td><td>D2232-3 -</td><td>Hinge plate</td><td><u>1/9419</u></td></tr><tr><td>2</td><td>D2581 -</td><td>Mounting Bracket</td><td><u>1/896</u></td></tr><tr><td>48 sf</td><td>M304EX0.75-16F</td><td>Expanded Metal</td><td><u>1/3571</u></td></tr></table>	Qty	Part Number	Description	Batch	2	D2327-3 -	Bushing	<u>1/8597</u>	2	D2232-3 -	Hinge plate	<u>1/9419</u>	2	D2581 -	Mounting Bracket	<u>1/896</u>	48 sf	M304EX0.75-16F	Expanded Metal	<u>1/3571</u>	MS	03/08/28	1
Qty	Part Number	Description	Batch																						
2	D2327-3 -	Bushing	<u>1/8597</u>																						
2	D2232-3 -	Hinge plate	<u>1/9419</u>																						
2	D2581 -	Mounting Bracket	<u>1/896</u>																						
48 sf	M304EX0.75-16F	Expanded Metal	<u>1/3571</u>																						
5	WS	Drill holes in three D2235-3 ribs as per Dwg D3053 using Jig DT8365	MS	03/08/28	1																				
6	WS	Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required ****Ensure ribs are positionned for RH****	MS	03/09/04	1																				
7	QC9 & 6	Inspect Welding and Dimensions	MS	03.09.04	1																				
8	WS	Take Traveller D205-541-044 to KP	MS	03.09.04	1																				
9	FP	Powder Coat White (Ref. 4.3.5.2) as per QSI 005 4.3	MS	03.09.16	1																				
10	QC3	Inspect Powder Coat	MS	03.09.16	1																				
11	FP	To GA Cell for Assembly	MS	03.09.16	1																				

Rev	Date	Change	Revised By	Approved
A	02.01.07	New issue	EC	
B	02.07.23	Re-format added D3166-1; removed inspect Level 5	KJ	
C	02.09.04	M304EX0.75-16F was M750-16FXS-S/S	KJ RF	

RELEASED
02/09/09 RF

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____

36

DART AEROSPACE LTD	Work Order:	19530
Description: 350/212/130 Basket Lid	Part Number:	D2512
Drawing: D2512 Rev. D1; D2236 Rev. B1	Qty:	1
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	OPEN MATERIAL 03.02.04 Dwg not required	JD	03.08.27	1
2	WS	Cut 3/4" x 3/4" square tubing as per Dwg D2512 Material: 304/316 SS tube .063" wall Batch: M13574 Cut Qty. 4 D2236 from: Qty. 1 D3166-3 - Batch D19428	M	03/08/28	1
3	WS	Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305	M	03/08/28	1
4	WS	Deburr	M	03/08/28	1
5	WS	Pick: Qty Part Number Description Batch 1 D2506 - Label Plate B19423 2 D2327-1 - Bushing B18927 2 D2232-1 - Hinge plate B18963 2 D2581 - Mounting Bracket B18966 18 sf M304EX0.75-16F Expanded Metal M13571	M	03/08/28	1
6	WS	D2012-117 is included in D3172-041 EC130 Basket Base BOM. EC130 Basket only Pick: Qty Part Number Description Batch 2 D2012-117 Clevis	KA	03-09-04	1
7	WS	Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required	M	03/09/04	1
8	QC6 & 9	Inspect Welding and Dimensions	JD	03-09-04	1
9	FP	Powder Coat White (Ref. 4.3.5.2) as per QSI 005 4.3	M	03-09-16	1
10	FP	Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 Batch: M13374 Batch: M13604	M	03-09-16	1
11	QC3	Inspect Powder Coat and Wing Walk	2	03-09-16	1
12	FP	To GA Cell for Assembly	2	03-09-16	1

Rev	Date	Change	
F	99.07.08	Dwg to Rev C, Ribs formed on bender	DM
G	00.02.03	Added Rib to pick list	EC
H	00.06.26	Removed P/O for powder coat	EC
J	01.04.30	Added D2232-1	EC
K	02.07.23	Re-format; Modify Step 2	KJ
L	02.09.04	M304EX0.75-16F was M750-16FXS-S/S	KJ
M	03.01.31	Added D2012-117 for D130-701-041	KJ/RF

RELEASED
03.02.05 RF

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#:_____ Fault Category:_____ DQA:_____ Date:_____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncb.doc

QA: N/C Closed: _____ Date: _____

Step	Location	Procedure	By	Date																												
1	PK	Remove from Stock Yes/No Return# _____ <table border="1"> <thead> <tr> <th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr> </thead> <tbody> <tr> <td>1</td><td>D205-541-044</td><td>Basket</td><td>B19530</td></tr> <tr><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td></tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D205-541-044	Basket	B19530																					B	04.04.14
Qty	Part Number	Description	Batch																													
1	D205-541-044	Basket	B19530																													
2		Re-work/Inspection: ① Disassemble Disassemble mounting hardware from basket ② Touchup with white powder coat: Basket D2199-1 strut D2199-23 strut D2199-25 strut D2498 lug D2499 lug D3052-1 lug ③ Remainder of kit needs to be picked (see IPP attached) ④ Inspect level 3 & level 4 ⑤ package as per PPP D205-541-044 Rev.C	B	04.04.14																												
3	PK	Identify & Stock: <table border="1"> <thead> <tr> <th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr> </thead> <tbody> <tr><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td></tr> </tbody> </table>	Qty	Part Number	Description	Batch																										
Qty	Part Number	Description	Batch																													
3	Sales	enter into finished inventory	B	04.04.21																												
	DC	Close W/O Inspect Level 21 1429.05 sur 04/04/21	K	04.04.21																												

36

DART AEROSPACE LTD	Work Order:	19530
Description: HELI-UTILITY-BASKET, RH	Part Number:	D205-541-044
Drawing: D205-541 Rev. E DSI 9131	Qty:	1
Page 1 of 2		

Step	Location	Procedure	By	Date	Qty																																																																																																																																																																
1	DC	Issue Travellers for: D205-541-044 Utility-Basket, RH D3053-042 Base D2512 Lid Drawing not required	Batch 19530 19530 19530	03.08.27	1																																																																																																																																																																
2	DC	Photocopy bluefile and type labels per PPP D205-541-044 CHG002	HK 35	03.08.29	1																																																																																																																																																																
3	WS	Go to traveler D3053-042 & D2512		03/08/25	1																																																																																																																																																																
4	KP	Pick: Assembly Kit <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D2022-101</td><td>Spacer</td><td>B19265</td></tr><tr><td>1</td><td>D2258-300</td><td>Label</td><td>B14384</td></tr><tr><td>1</td><td>D2332-041</td><td>Prop Ass'y</td><td>B19413</td></tr><tr><td>1</td><td>D2530</td><td>Handle Ass'y</td><td>B19487</td></tr><tr><td>2</td><td>D2535</td><td>Spring</td><td>B17762</td></tr><tr><td>2</td><td>D2537</td><td>Bushing</td><td>B18840</td></tr><tr><td>2</td><td>D2931</td><td>Bumper</td><td>B18293</td></tr><tr><td>2</td><td>AN3-16A</td><td>Bolt</td><td>H10454</td></tr><tr><td>2</td><td>AN4-7A</td><td>Bolt</td><td>H13237</td></tr><tr><td>1</td><td>AN4-22A</td><td>Bolt</td><td>M12490</td></tr><tr><td>1</td><td>AN4-24A</td><td>Bolt</td><td>M11492</td></tr><tr><td>4</td><td>AN5-17A</td><td>Bolt</td><td>M13237</td></tr><tr><td>2</td><td>AN960JD416</td><td>Washer</td><td>M13356</td></tr><tr><td>2</td><td>AN960JD416L</td><td>Washer</td><td>M3154</td></tr><tr><td>4</td><td>AN960JD516</td><td>Washer</td><td>M11989</td></tr><tr><td>2</td><td>AN960JD8</td><td>Washer</td><td>M9636</td></tr><tr><td>4</td><td>AN970-4</td><td>Washer</td><td>M12963</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M13536</td></tr><tr><td>4</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M12620</td></tr><tr><td>4</td><td>MS21042L5</td><td>Nut (or -5)</td><td>M5289</td></tr><tr><td>2</td><td>MS20600AD4W3</td><td>Rivet</td><td>M12289</td></tr></table> Pick: Packing Kit <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2199-1</td><td>Strut</td><td>B1821</td></tr><tr><td>1</td><td>D2199-23</td><td>Strut</td><td>B11406-B10730-B12793</td></tr><tr><td>1</td><td>D2199-25</td><td>Strut</td><td>B10731-B12794-B11407</td></tr><tr><td>1</td><td>D2498</td><td>Mounting lug</td><td>B3924</td></tr><tr><td>1</td><td>D2499</td><td>Mounting lug</td><td>B17619</td></tr><tr><td>2</td><td>D2515</td><td>Bushing</td><td>B18029</td></tr><tr><td>1</td><td>D3052-1</td><td>Mounting lug</td><td>B18143</td></tr><tr><td>2</td><td>AN4-7A</td><td>Bolt</td><td>M13237</td></tr><tr><td>3</td><td>AN4-12A</td><td>Bolt</td><td>M14820</td></tr><tr><td>9</td><td>AN4-13A</td><td>Bolt</td><td>M14782</td></tr><tr><td>2</td><td>AN4-14A</td><td>Bolt</td><td>M13103</td></tr><tr><td>1</td><td>AN5-7A</td><td>Bolt</td><td>M5760</td></tr><tr><td>1</td><td>AN5-13A</td><td>Bolt</td><td>M10383</td></tr><tr><td>29</td><td>AN960JD416</td><td>Washer</td><td>M14312</td></tr><tr><td>3</td><td>AN960JD516</td><td>Washer</td><td>M14076</td></tr><tr><td>16</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M14149</td></tr><tr><td>2</td><td>MS21042L5</td><td>Nut (or -5)</td><td>M5289</td></tr></table>	Qty	Part Number	Description	Batch	2	D2022-101	Spacer	B19265	1	D2258-300	Label	B14384	1	D2332-041	Prop Ass'y	B19413	1	D2530	Handle Ass'y	B19487	2	D2535	Spring	B17762	2	D2537	Bushing	B18840	2	D2931	Bumper	B18293	2	AN3-16A	Bolt	H10454	2	AN4-7A	Bolt	H13237	1	AN4-22A	Bolt	M12490	1	AN4-24A	Bolt	M11492	4	AN5-17A	Bolt	M13237	2	AN960JD416	Washer	M13356	2	AN960JD416L	Washer	M3154	4	AN960JD516	Washer	M11989	2	AN960JD8	Washer	M9636	4	AN970-4	Washer	M12963	2	MS21042L3	Nut (or -3)	M13536	4	MS21042L4	Nut (or -4)	M12620	4	MS21042L5	Nut (or -5)	M5289	2	MS20600AD4W3	Rivet	M12289	Qty	Part Number	Description	Batch	1	D2199-1	Strut	B1821	1	D2199-23	Strut	B11406-B10730-B12793	1	D2199-25	Strut	B10731-B12794-B11407	1	D2498	Mounting lug	B3924	1	D2499	Mounting lug	B17619	2	D2515	Bushing	B18029	1	D3052-1	Mounting lug	B18143	2	AN4-7A	Bolt	M13237	3	AN4-12A	Bolt	M14820	9	AN4-13A	Bolt	M14782	2	AN4-14A	Bolt	M13103	1	AN5-7A	Bolt	M5760	1	AN5-13A	Bolt	M10383	29	AN960JD416	Washer	M14312	3	AN960JD516	Washer	M14076	16	MS21042L4	Nut (or -4)	M14149	2	MS21042L5	Nut (or -5)	M5289		03/09/25	1
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REFERENCE

03-09-25

01/01/22

REFERENCE ONLY

inspection of Kit

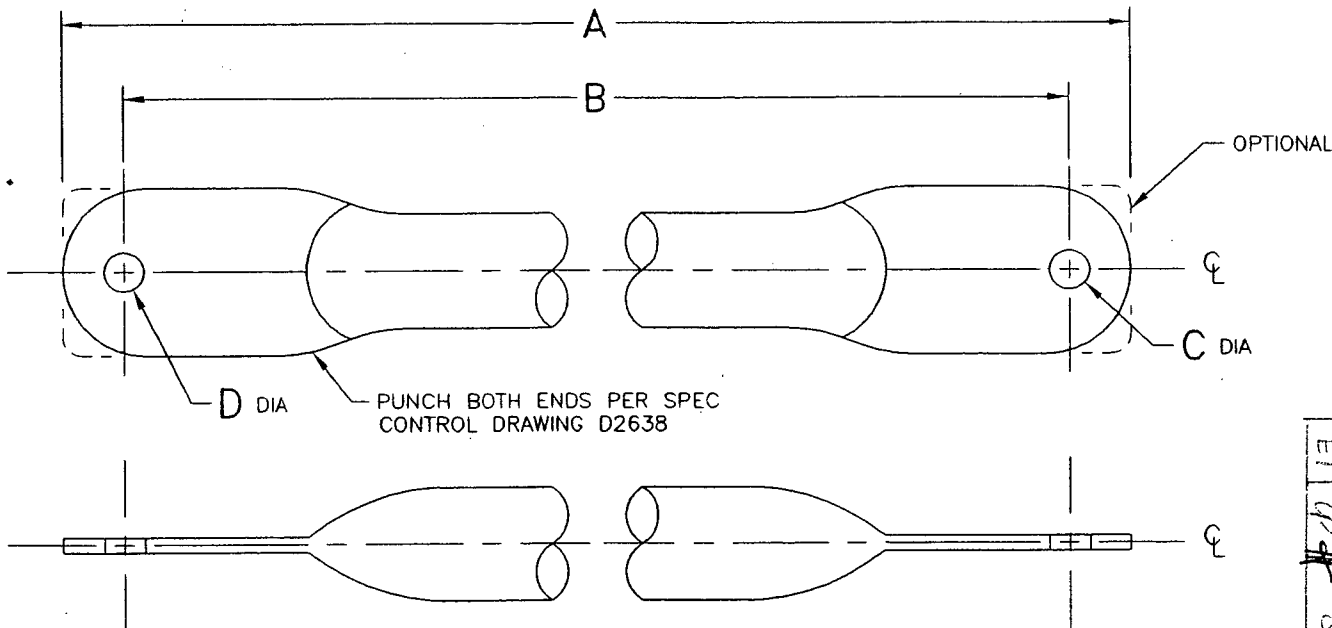
DB 03-10-01 mm

RELEASED
02/09/03 RF



RELEASED
98.05.05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E	
DATE		D2199	SHEET 1 OF 1	
98.04.28		TITLE	SCALE	
		STRUT DETAILS	NTS	
A	1993	NEW ISSUE		
B		ADDED -11, -13, AND -15		
C		ADDED -17 AND -19		
D		ADDED -21		
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD		
E1	CP 02.03.22	ADD FINISH		



CONTROLLED COPY

B
B
B
C
C
D
E
E

100.10.13
CP 00.10.13

	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
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D2199-29	21.11	20.31	0.257	0.257

REFERENCE ONLY

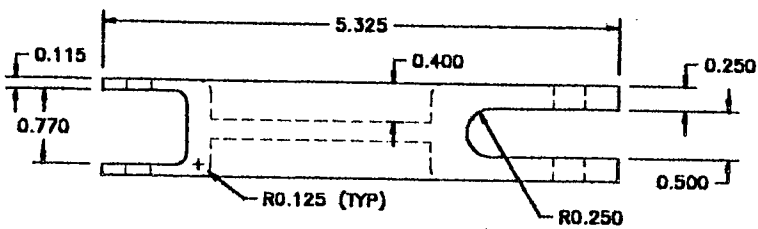
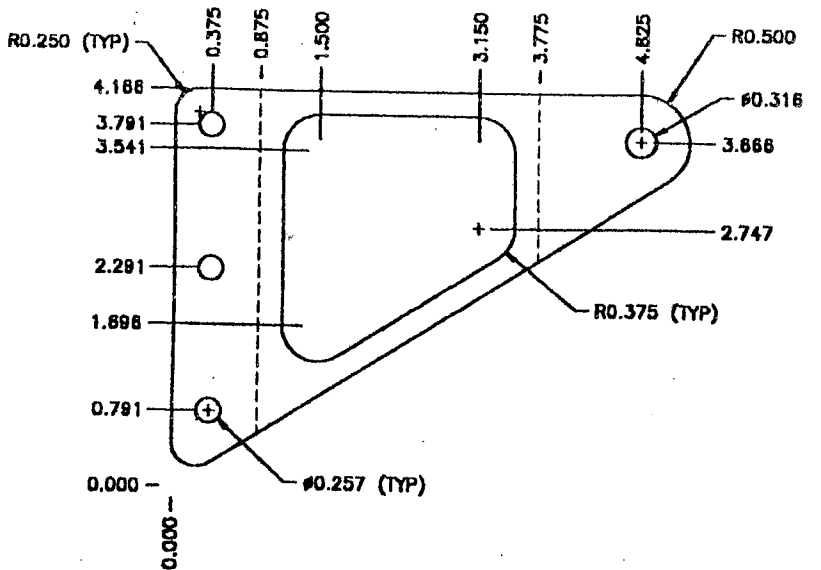
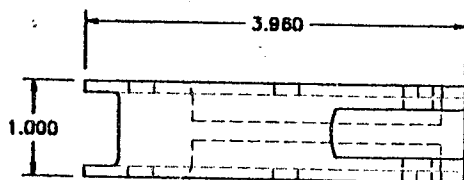
NOTES:

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.750 x 0.049 WALL
3. FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3/E1



DESIGN	B WILLIAMS	DRAWN BY	K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. A
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2498	SHEET 1 OF 1
DATE	95:11:09	TITLE	MOUNT	SCALE	1:2

CONTROLLED COPY



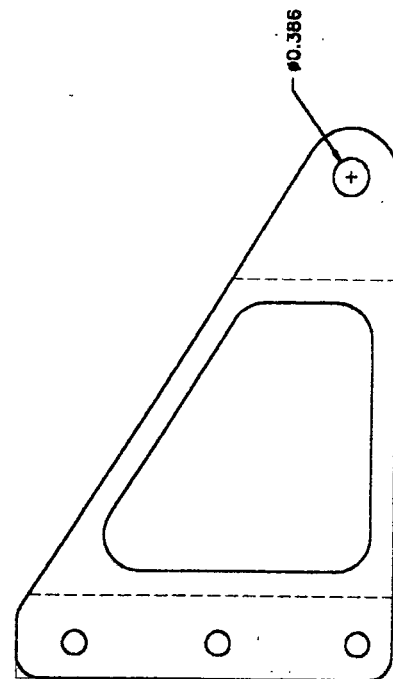
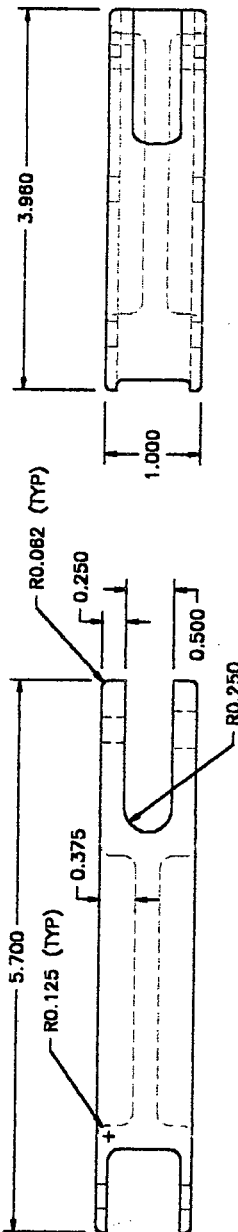
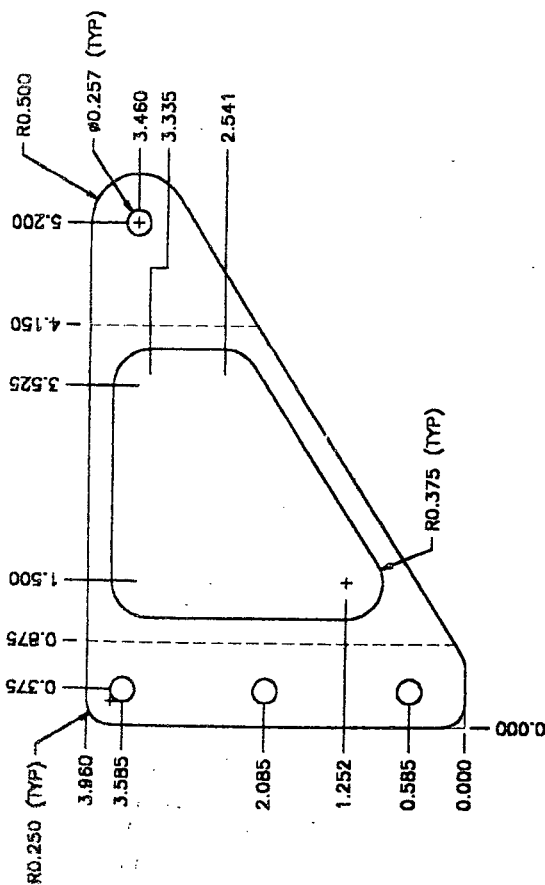
REFERENCE ONLY

MATERIAL: 6061-T6 ALUMINUM



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. B
CHECKED <i>Bu</i>	APPROVED <i>[Signature]</i>	D2499	SHEET 1 OF 1
DATE	TITLE	SCALE	
95:11:09	MOUNT	1:2	
B	95.12.06	CHANGE HOLE DIA TO .386	

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REFERENCE ONLY

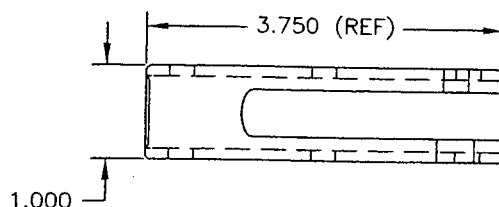
MATERIAL: 6061-T6



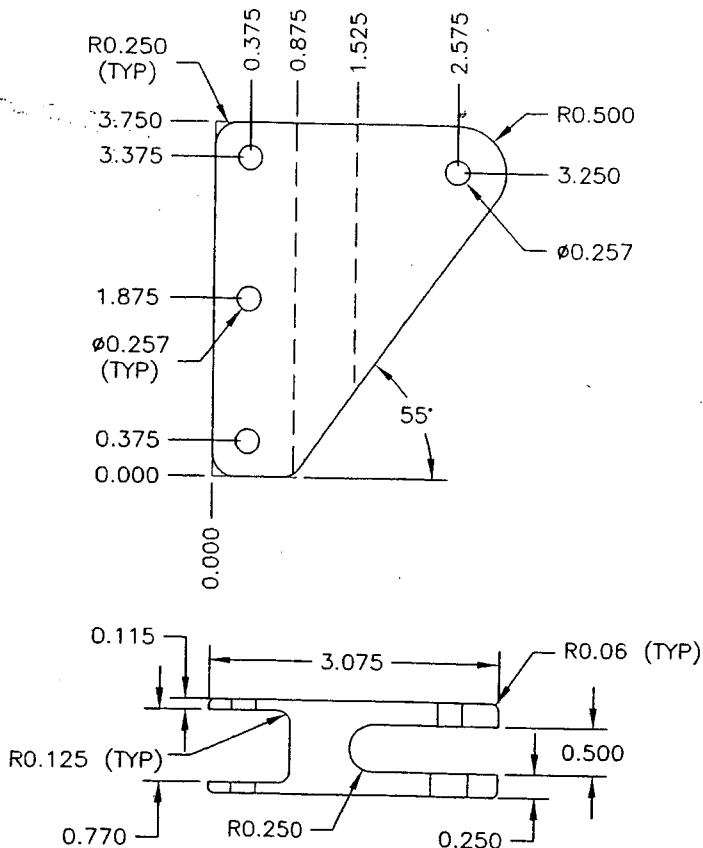
DESIGN	DRAWN BY	DART AEROSPACE LTD	
REV. A	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
DATE	01.11.01	D3052	SHEET 1 OF 1
01.11.01	01.11.01	MOUNTING LUG	SCALE 1:2
A	01.11.01	NEW ISSUE	

RELEASED
01.12.20

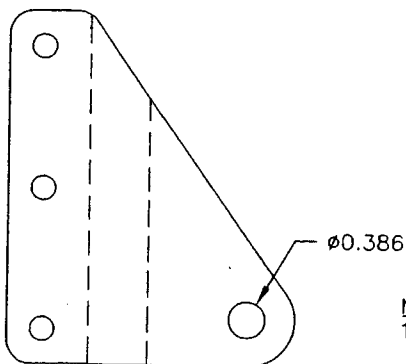
CONTROLLED COPY



D3052-1 MOUNTING LUG



REFERENCE ONLY



NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8) 1.00 THICK
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED